

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010784**Date Inspected:** 17-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW buttering repair welding adding a minimum of 20mm to ends of various north tower, lift 1, strut plates per ZPMC weld repair report T-WR2695. Welder was identified as 053116. ZPMC QC was identified as CWI Du Zhi Qun (QC1). The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-repair.

ABF representatives performing magnetic particle testing (MT) on the following struts: ED1-A6001-8, ED1-A6001-5, ED1-A6003-3.

SMAW welding of weld joints ND1-6002-14-19, 20, 45, 46 located on PCMK north tower, strut. Welder was identified as 056354. ZPMC QC was identified as QC1. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

FCAW welding on the copes at the shear plates at the bottom of north tower, lift 1, skin C. Welder was identified as 054069. ZPMC QC was identified as CWI Wang Chuan Qin (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Yuan Hui Gang, who was not a CWI. The

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welding variables recorded by QC's assistant appeared to comply with WPS-B-T-2333-TC-P4-F.

FCAW welding on the copes at the shear plates at the bottom of north tower, lift 1, skin C and skin D. Welder was identified as 052075. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC's assistant appeared to comply with WPS-B-T-2333-TC-P4-F. Also present at this location and appearing to be monitoring the welding operation was ABF Representative Yang Ye Heng.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
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Reviewed By:	Dawson, Paul	QA Reviewer
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